

Work Order ID 156110

Thursday, January 26, 2017 10:38:36 AM

156110

Page 1

Item ID: D3997-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Placard

Start Date: 1/31/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/14/2017 Req'd Qty: 6.00

6

Customer:

Reference:

DAS
21

Approvals:

Process Plan:

9-89

Date: JAN 26 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3997

B

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O:

35130

Manufacture as per Dwg D3997

Possible Supplier: Studio Lettrage

Material release note required

6 JAN 30 2017

DAS
13
9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

6 DAS
6
9-89

FEB 03 2017

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

6

DAS
38
9-89

FEB 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Work Order ID 156110

Thursday, January 26, 2017 10:38:36 AM

156110

Page 2

Item ID: D3997-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Placard

Start Date: 1/31/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/14/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: Job 1

0.00

130

Packaging

Memo

0.00

Packaging

***ONE YEAR EXPIRED DATE FROM
RECEIVING: _____***

FEB 02 2017

FEB 06 2017
DAS 6 6-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

DAS
21
9-89

FEB 06 2017



FEB 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, January 26, 2017 10:38:40 AM

Page 1

Work Order ID: 156110

156110

Parent Item: D3997-1

D3997-1

Parent Item Name: Placard

Start Date: 1/31/2017

Required Date: 2/14/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A 10.01.12 new issue Prelim EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1P		Purchased	No			100	Each	0.0000	1	6			
D3997-1P									**				
Placard													

DAS
6
9-89

FEB 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

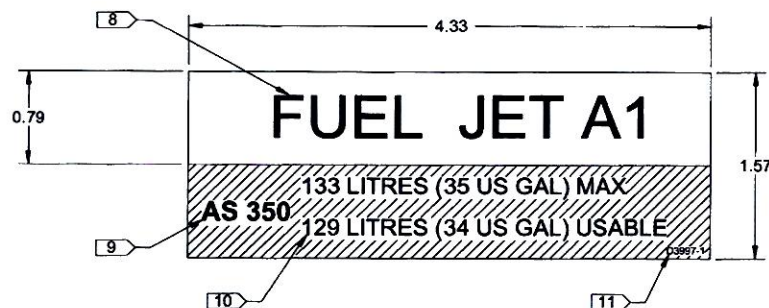
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

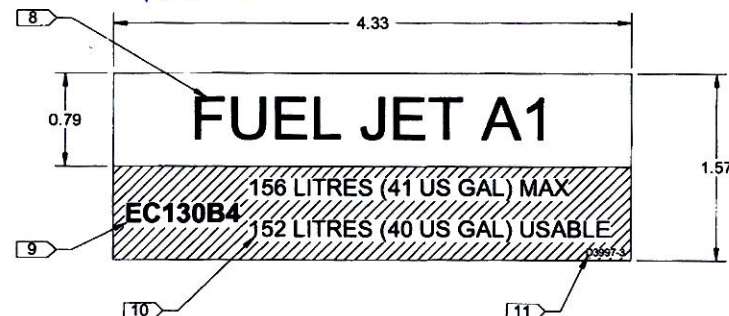
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3997-1	JCA-M47-P1
D3997-3	JCA-M47-P2

PART NUMBER	INSTALLATION INSTRUCTIONS
D3997-1	FOR AS350 AIRCRAFT - ADJACENT TO FUEL FILLER
D3997-3	FOR EC130 AIRCRAFT - ADJACENT TO FUEL FILLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 156110 MLJ
1701-26



D3997-1 PLACARD



D3997-3 PLACARD

RELEASED
2014-06-11

NOTES:

- 1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AS PER NOTES 8-11 ON SHEET 1
- 7) WEIGHT: LESS THAN 0.01 LBS
- 8) 36 PT FONT, BLACK TEXT ON WHITE BACKGROUND
- 9) 16 PT BOLD FONT, WHITE TEXT ON BLACK BACKGROUND
- 10) 14 PT FONT, WHITE TEXT ON BLACK BACKGROUND
- 11) 6 PT FONT, WHITE TEXT ON BLACK BACKGROUND

B	REVISED D3997-27 TO A HEIGHT OF 3.0 (ZN B2-4)	ML	13.11.05
A	NEW ISSUE		09.10.05
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP		
MFG. APPR.	JLM		
APPROVED	MP		
DE APPR.	DS	PLACARD	
DATE	13.11.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

A



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO35130

Purchase Order Date 1/30/2017

PO Print Date 1/30/2017

Page Number 1 of 3

Order From :

VC-STU001

Ship To : DART AEROSPACE LTD

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JAN 30 2017

Contact Name

Vendor Phone 613 632 5449

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2137P AS PER DWG D2137 REV. JAN 29 1992 B156103	Decal - No Step	2/6/2017 Yes 2/6/2017		6.00 Each	\$13.33	\$80.00
Line Total:							\$80.00
2	D3997-1P AS PER DWG D3997 REV. B B156110	Placard	2/6/2017 Yes 2/6/2017		6.00 Each	\$13.33	\$80.00
Line Total:							\$80.00
3	D3997-7P AS PER DWG D3997 REV. B B156111	Placard	2/6/2017 Yes 2/6/2017		6.00 Each	\$13.33	\$80.00

Note:

1/30/2017

FEB 02 2017

DA
6
9.2

studio sl2

210 Main West
Hawkesbury, Ontario K6A 2H6
Canada

INVOICE

Invoice No.: 43788
Date: 02/01/2017
Ship Date:
Page: 1
Re: Order No.

Sold to:

Dart Aerospace Ltd
Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Ship to:

Dart Aerospace Ltd
Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Quantity	Description	Unit Price	Amount
6	D2137P.	13.33	79.98
6	D3997-1P.	13.33	79.98
6	D3997-7P.	13.33	79.98
6	D4385-1P.	13.33	79.98
6	D4862-3P.	13.33	79.98
	PO#35130		
	Subtotal:		399.90
	H - HST		
	HST		52.00
	FEB 03 2017		
	DAS 6 9:59		
Thank you for your business / Merci de faire affaire avec nous			
Shipped By:	Tracking Number: HST: 825007651RT0001	Total Amount	451.90
Comment: WO 19603		Amount Paid	0.00
Sold By:		Amount Owing	451.90

******CERTIFICATE of CONFORMITY******

Customer:

Studio SL2

Purchase Order N°:

PO# 19603

Packing Slip N°:

WO# 19603

Part N°:

Serial N°:

Description:

D2137P, D3997-IP, D3997-7P,
D4385-IP.

Quantity:

6, 6, 6, 6, 6.

Certification:

We hereby certify that:

1. The above listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

Avery

APPROVAL: Valerie Young

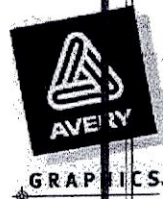
Signature: Val Y

Title: office administrator.

DATE:

Feb 01. 17.

PRODUCT DATA SHEET



Avery® IPM I™ 7112

issued: 15/04/2002

Introduction

Avery IPM I 7112 is a white monomeric calendered removable self-adhesive vinyl for use on the Idanit 162Ad inkjet printer, providing good machine runnability. Because of its cost efficiency and good removability, Avery IPM I 7112 is recommended for a wide range of short term applications on flat substrates requiring easy and clean removal.

Description

Film : 100 micron gloss white monomeric calendered vinyl
Adhesive : **removable**, acrylic based
Backingpaper : kraft paper, 140 g/m²

Conversion

Avery IPM I 7112 is specially developed for use on the Idanit 162Ad and Idanit Novo inkjet printer and has been officially approved by Idanit using BL and Magic inks.

Uses

- Interior & exterior signs.
- Window decoration.
- Temporary promotional and point of sale advertising and all.
- applications to flat or regular surfaces that require removability.

Features

- Good printability and handling on Idanit 162Ad.
- Easy conversion.
- Most economical solution for short term outdoor graphics.
- Easy and clean removal (up to 1 year).



Graphics Division
Rijndijk 86, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538

PRODUCT CHARACTERISTICS

Avery® IPM I™ 7112

Physical properties

Features	Test method ¹	Results
Caliper, facefilm	ISO 534	100 micron
Opacity	ISO 2471	92%
Dimensional stability	DIN 30646	0.3 mm max.
Adhesion, initial	FINAT FTM-1, stainless steel	225 N/m
Adhesion, ultimate	FINAT FTM-1, stainless steel	400 N/m
Flammability		Self extinguishing
Shelf life	Stored at 22° C/50-55 % RH	2 years
Removability		up to 1 year*
*Not when applied to: Nitrocellulose paints, ABS, Polystyrene, screenprinting inks (fresh), certain types of PVC		
Durability, unprinted	Vertical exposure	2 years

Temperature range

Features	Results
Minimum application temperature:	≥ 0° C
Temperature range:	- 40 to +100 °C

Important

Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use. All technical data are subject to change.

Warranty

Avery® branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing. All Avery® branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

1) Test methods

More information about our test methods can be found on our website.

2) Durability

The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.



Graphics Division
Rijndijk 86, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538